

Date: Wednesday, 29/10/2008 10:19:39 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD BLADE FOLD ASSEMBLY
Job Number :	43066		
Estimate Number :	13531		
P.O. Number :		Part Number :	PB674300101
This Issue :	29/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1, 2
First Issue :	//	Project Number :	N/A
Previous Run :	42214	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	05/11/2008
Written By :		Qty:	1
		Um:	Each
Checked & Approved By :	mf 08-10-20		
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwd Blade Fold Assembly Weldment batch: <u>B43063</u>	
		mf 08-12-04
2.0	PB674300115	Fwf Adjustable Blade Support Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <u>B43059</u>	
		mf 08-12-04
3.0	PB674300111	Fwf Adjustable Blade Support Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <u>B43081</u>	
		mf 08-12-04
4.0	PB674300121	PB67-43001-21
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-21 batch: <u>B41292</u>	
		mf 08-12-04
5.0	PB674300123	PB67-43001-23
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-23 batch: <u>B43057</u>	
		mf 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Longitudinal Support Assembly

batch: 41013

mf 08-11-03

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Long T-Handle Assembly

batch: 41381

mf 08-11-03

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Lever Arm

batch: 41294

mf 08-11-03

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

batch: 41373

mf 08-11-03

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

batch: 340062

mf 08-11-03

11.0

D3451041

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: B42995

wip mf 08-12-04

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: B41355

wip mf 08-12-04

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Spacer

batch: 41351

MF 08-11-03

14.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Swing Arm

batch: 41352

MF 08-11-03

15.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Belt Assembly

batch: B39966

MF 08-11-03

16.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: m109350

MF 08-11-03

17.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: 18431

MF 08-11-03

18.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: m18057

MF 08-11-03

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: m109031

MF 08-11-03

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut

batch: m108145

mf 08-10-03

21.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: m108183

mf 08-11-03

22.0

MS51859

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: m106271

mf 08-11-03

23.0

MS51859

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: m108986

mf 08-11-03

24.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SPACER

batch: m109060

mf 08-11-03

25.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

batch: m109031

mf 08-11-03

26.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch: m18057

mf 08-11-03

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: 18057

MF 08-11-03

28.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

batch: m18057

MF 08-11-03

29.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch: 6085

MF 08-11-03

30.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

batch: m107178

MF 08-11-03

31.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

batch: m109285

MF 08-11-03

32.0

AN415A

Bolt



AN415A m108868



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch: m108471

MF 08-11-03

33.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

BOLT

batch: m105558

MF 08-11-03

Process Sheet

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Job Number: 43066

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN620A

AN6 C 16 A.

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m105831

mf 08-12-04

35.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m108986

mf 08-11-03

36.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIVET

batch: m109119

mf 08-11-03

37.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: m104214

mf 08-11-03

38.0

MS17984C408

PIN, QUICK RELEASE



ms17984C-410



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m18118

mf 08-12-04

39.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m108473

mf 08-12-04

40.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

8" LANYARD

batch: m108340

mf 08-11-03

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

LANYARDS

batch: M108973

mf 08-11-03

42.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850

mf 08-11-03

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2

242 THREADLOCK batch: M1109687

mf 08-12-04

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/04

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: JPP

43067

6/12/04 850

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/04

Job Completion



42.1 Add D3447-7-x2

B 41552x1
B 43895x1

mf 08-12-04

NOTICE: INFORMATION CONTAINED HEREIN IS PROPRIETARY TO PREMIER AVIATION, INC. AND MAY NOT BE RELEASED OR REPRODUCED WITHOUT PRIOR WRITTEN AUTHORIZATION BY PREMIER AVIATION, INC.

REV STATUS	REV	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45
OF SHEETS	SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	WIG. REITASE	10/12/95	WH
2	CHANGES TO IMPROVE FUNCTIONALITY	3/7/96	WH
3	DWG AND P/L REVISED AND UPDATED TO REFLECT BILL MODIFICATIONS	8/15/96	WH
4	CHANGED DESIGN AFTER FIT & FUNCTION TEST C160 TT-042-645-10	8/30/96	

NOTES (UNLESS OTHERWISE SPECIFIED):

- IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-12112. LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
- FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
- GENERAL SHOP PRACTICES I.A.W. PREMIER SPEC. 008-93000 AND AC43.13.
- OPEN
- WELD PARTS PER MIL-2219, CLASS B.
- CHEM FILM (ALODINE) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC 008-93003, CLASS 1A, AND PRIME WITH EPOXY PRIMER PER MIL-P-23377C, ZINC CHROMATE PRIMER PER MIL-ITP-1757, OR EQUIVALENT.
- STITCHING PER FED-STD-751.

WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (T-HANDLE LOCKED ON LOWEST HOOK), DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RESTED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE, .25 DIA.

INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT 803073 SET P.I.N. AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL 12 PL EA BUSHING

GRIND BUSHING AND WELD TO CONTOUR OF TUBE.

ALIGN CRADLE ASSEMBLY 90 DEGREES FROM THE CENTERLINE AXIS OF THE BUSHING ON THE OTHER END OF THE TUBE. WELD GUSSET ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.

CHAMFER EDGE FOR BETTER WELDING.

TAP HOLE TO 1/4-20 THRU.

INSTALL CL-4R-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO PUNCH THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER STOWING.

PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN960 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.

PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED, EXCEPT WHERE NOTED, 23663U W OHS A YELLOW, PER FED-STD-525.

NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE, PER PREMIER SPEC 008-93003.

STITCH APPROX AS SHOWN, PER FED-STD-751.

PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER NSS1859 EQUIVALENT.

DISENGAGE -53 HANDLE ASST (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASST TO AIRCRAFT.

SECURE -43 BELT ASST TO TOP OF -65 (OF -05) OR -47 (OF -07). LOCATE APPROX AS SHOWN.

WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137

DRILL WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.

SHIM AS REQD, USING NAS1149D0332J WASHERS.

-01 FWD BLADEFOLD ASST FOR COMMERCIAL VERSIONS ONLY
-02 FWD BLADEFOLD ASST FOR CANADIAN VERSIONS ONLY

TOLERANCE ON DECIMAL .X ±.1

LAST SECTION LETTER USED "L"

DRILL NO. 30 (Ø.128) HOLE THRU -37 AND AND -25 (COMPONENT OF -09 ASSY). INSERT 803073 SET P.I.N. AND GRIND FLUSH WITH -37.

43066

REFERENCE ONLY

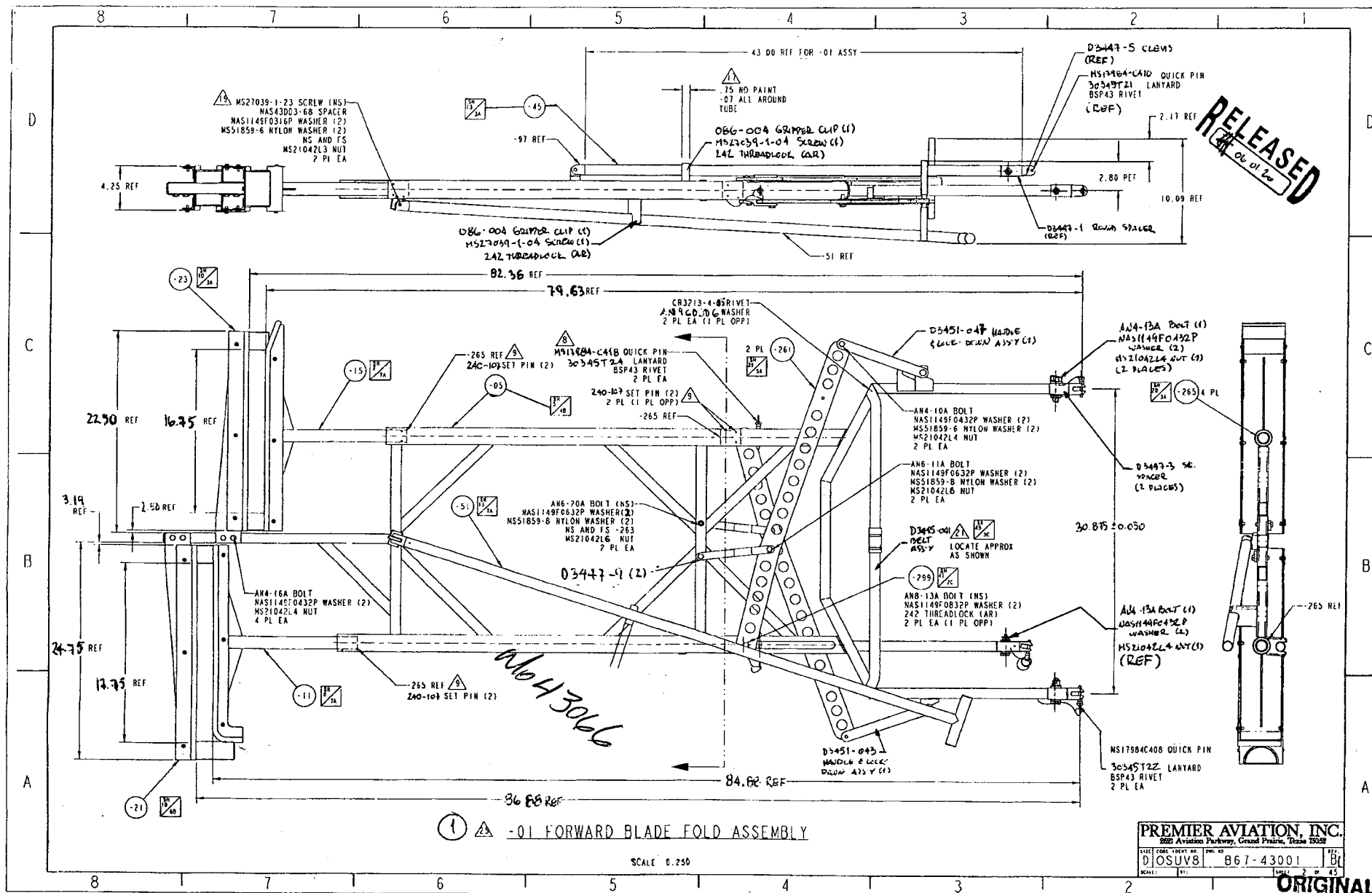
SEE SEPARATE PARTS LIST B67-43001PL

MATERIAL:		DIMENSIONS OTHER THAN SPECIFIED ARE IN INCHES		DATE: 10/12/95		PREMIER AVIATION, INC.	
TOLERANCE ON DECIMALS		ANGLES		CHECKED BY: RICK REYNOLDS		DATE: 10/12/95	
.25 ±.00		AT/2°		APPROVED BY: WALT HAMAKER		DATE: 10/12/95	
USED NO. 851473		NEXT WISHER ASSEMBLY		RELEASED BY:		DATE:	
REPLAZEP				ACTIVED DRAWN BY: Pro/ENGINEER		SCALE: 1:1	
				SHEET 1 OF 45		REV. 1	

RELEASED
06-01-20

ECO
5007
5161
6262

ORIGINAL



REFERENCE ONLY